

Work Order ID 82668

82668

Page 1

Item ID: D2957

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Mounting Plate

Stop ***NS2***

Start Date: 04/04/2012 Start Qty: 12.00

12

Cust Item ID:

Required Date: 18/04/2012 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/04 Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2957

Rev B

100

0.00

100

BAND SAW

FR 12/04/15

15

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 10.500" long
1 blank makes 5 parts

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS #1

Memo

0.00

HAAS CNC vertical machine #1

Machine as per folio FA042
Deburr

15 0 SS 12/04/18

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

15 0 SS 12/04/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82668

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Run Start ***NR1***

QC:

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SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
150	Identify as per dwg & Stock Location: STWA	0.00							
150									
Packaging	Memo	0.00							
Packaging	*****STOCK IN BASKET CELL*****								
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

2nd 12.4.18

13x

Sp
12-04-19,

12/4/19

12-04-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 82668

82668

Parent Item: D2957

D2957

Parent Item Name: Mounting Plate

Start Date: 04/04/2012

Required Date: 18/04/2012

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: C00.08.09New dwg rev B (mpp 2078)EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.500X01.25 0		Purchased	No			100	f	12.1700	0.175	2.210526			

M6061T6B0 500X01 250

6061-T6 Bar .500 x 1.25

**

FK- 12/04/15

Location

Loc Qty

Loc Code

MAT001

12.17

103019

6.75

7872

5.42

2.211

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DART AEROSPACE LTD		Work Order:	82668
Description: Mounting Plate		Part Number:	D2957
Inspection Dwg: D2957 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.25	+/-0.030	0.248	✓		SLO8	VERN
0.068	+/-0.010	0.0675	✓			
Ø0.323	+/-0.010	Ø0.3235	✓			
0.250	+/-0.010	0.249	✓			
1.06	+/-0.030	1.063	✓			
0.875	+/-0.010	0.8738	✓			
0.449	+/-0.010	0.4505	✓			
R0.12	+/-0.030	R.125	✓		Rad Gauge	
1.85	+/-0.030	1.852	✓		SLO8	VERN
0.250	+/-0.010	0.246	✓			
0.19	+/-0.030	0.186	✓			
0.125	+/-0.010	0.125	✓			

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	12/04/18	Date:	12.1.18	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue	KJ/RF <i>[Signature]</i>	<i>[Signature]</i>

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

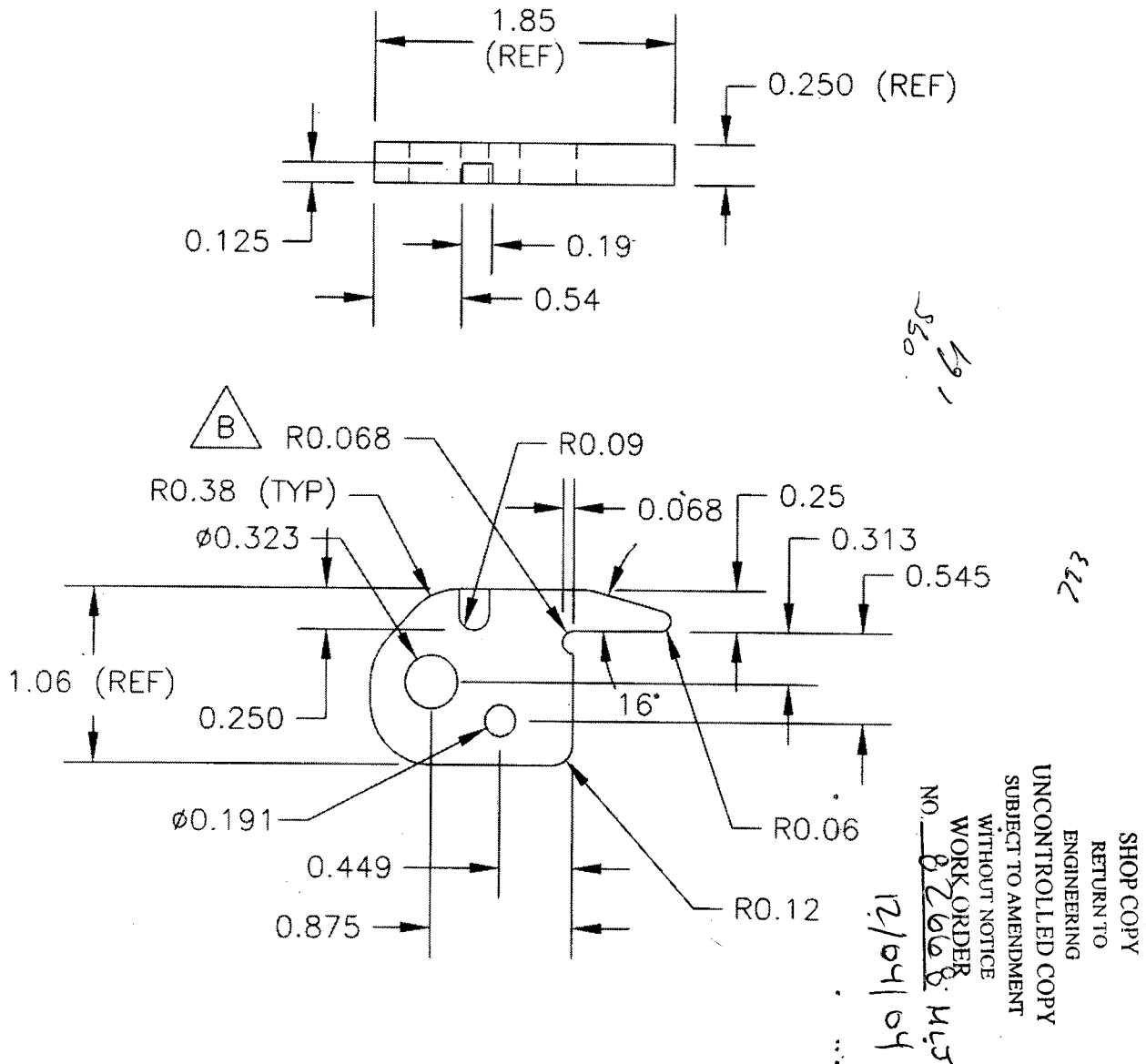
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DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2957	REV. B SHEET 1 OF 1
DATE 00.07.06		TITLE MOUNTING PLATE	SCALE 1:1
A	00.01.20	NEW ISSUE	
B	00.07.06	MODIFY CORNER DETAIL	

RELEASED
00.07.18 [Signature]



MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8 OR QQ-A-250/11) 0.250 THICK
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
BREAK ALL SHARP EDGES 0.010 TO 0.020

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Dart Aerospace Ltd

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